

TIG Rods C-Mn steels and low-alloy steels

CARBOROD CrMo5 is a copper coated WCrMo5Si/ER 80S-B6 type solid TIG welding rod depositing a nominal C-0.3Mn5.6Cr0.6Mo low alloy steel weld metal. Suitable for use with Ar shielding gas.

CARBOROD CrMo5 is used for welding elevated temperature creep resisting steels of similar composition (P/T5) as used in the power generation and petrochemical industries where corrosion resistance to steam, hot hydrogen gas and high sulphur crude oils is a requirement.

Classification	
EN ISO	21952-A: W CrMo5 Si
AWS	A5.28: ER 80S-B6

Chemical analysis (Typical values in %)

C	Mn	Si	P	S	Cr	Mo
0.07	0.5	0.5	≤ 0.020	≤ 0.020	5.7	0.6

All-weld metal Mechanical Properties

Heat Treatment	Yield Strength (MPa)	Tensile Strength (MPa)	Elongation A5 (%)	Impact Energy ISO - V (J)	
				+20 °C	-30 °C
760 °C x 1h	≥ 470	≥ 590	≥ 20	≥ 100	≥ 60

Gas test: 100% Ar


Shielding Gas - EN ISO 14175 : I1

Materials

A 336 Cl. F5, A 369 Gr. FP5, A 387 Gr.5, Cl 1 and 2

12CrMo19-5, X12CrMo5; A182 Gr. F5, A199 Gr. T5, A213 Gr.T5, A335 Gr.P5

Storage
Keep dry and avoid condensation

Current condition and welding position
DC-


Packaging data

Diam. (mm)	Packaging Type	Weight (kg)	Code
1.6	TUB	5	●